

Split

Dart Aerospace Ltd.

Date: Tuesday, 08/01/2008 3:19:44 PM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 03.250 SUPPORT
Job Number : 35582 -1 Part Number : D29401
Estimate Number : 10387 Drawing Number : D2940 REV B
P.O. Number : Project Number : N/A
This Issue : 08/01/2008 S.O. No. : Drawing Revision : B
Prsht Rev. : NC Material :
First Issue : 06/11/2007 Type : MACHINED PARTS Due Date : 13/12/2007
Previous Run : 35478 Qty: 32 Um: Each
Written By : *[Signature]* 08-01-08
Checked & Approved By :
Comment : Est. C 02.11.26 Reformat; Added P/O KJ
Est Rev:D Added priming as per Rev B 07-04-30 JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6104007	17-4 SS Roundbar 4.50"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)
17-4 SS Roundbar 4.50"OD
D6104-007
BATCH: 35582A *[Handwritten: 35475A X8]*

2.0	35582A	ROUND BILLET 17-4
-----	--------	-------------------



Comment: Sub-Component ROUND BILLET 17-4
D6104-007 B

3.0	DOOSAN LATHE	DOOSAN LATHE
-----	--------------	--------------



Comment: Doosan
Turn blank for Haas as per Folio FA079

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

5.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS
1- Machine as per Folio FA079
2- Tumble & Deburr

Date: Tuesday, 08/01/2008 3:19:44 PM
User: Jean-Luc Menard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 03.250 SUPPORT

Job Number: 35582

Part Number: D29401

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

7/21/20/3.1 08/01/07

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7/21/08-04-07 08-04-07 (2)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

*****Mask Inside Surface as per Dwg D2940*****

Ph 107550

08-04-07

(16)

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2940 and QSI 005 4.3.

7T 08 04 07

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7T 08 - 04 - 08

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *X-tube assy*

7T 08-04-08

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/09

Job Completion



(16)

*W
mf*

08-04-08

DART AEROSPACE LTD	Work Order: 35582
Description: Ø3.250 Support	Part Number: D2940-1
Inspection Dwg: D2940 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.726	.726	.724	.724		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.120	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.150	.150	.156	.155		
AD	3.510	3.530		3.514	3.525	3.523	3.522		
AE	1.633	1.673		1.647	1.656	1.656	1.664		
AF	1.493	1.513		1.497	1.502	1.500	1.506		
AG	0.040	0.060		.051	.050	.052	.053		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.148	.153	.153	.155		
AJ	2.518	2.538		2.530	2.530	2.530	2.530		
AK	0.040	0.060		.051	.051	.053	.052		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.154	.154	.152	.152		
AN	0.350	0.450		.355	.355	.360	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.150	.154	.155	.157		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.260	.260	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.128	4.126	4.127	4.126		
AV									
Accept/Reject									

Measured by: <i>JP / J.L</i>
Date: <i>08/03/15 08/04/06</i>

Audited by: <i>[Signature]</i>
Date: <i>08.04.07</i>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM <i>[Signature]</i>	<i>BE</i>

DART AEROSPACE LTD				Work Order: 35582	
Description: Ø3.250 Support				Part Number: D2940-1	
Inspection Dwg: D2940 Rev. B				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.725	.725	.721	.725		
D	0.090	0.110		.103	.102	.102	.103		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.152	.153	.152	.151		
AD	3.510	3.530		3.523	2.522	2.523	2.524		
AE	1.633	1.673		1.662	1.661	1.661	1.660		
AF	1.493	1.513		1.504	1.504	1.506	1.502		
AG	0.040	0.060		.052	.053	.053	.052		
AH	0.188	0.193		.188	.188	.188	.188		
AI	0.140	0.160		.152	.153	.152	.153		
AJ	2.518	2.538		2.530	2.530	2.530	2.530		
AK	0.040	0.060		.052	.051	.050	.051		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.153	.152	.149	.148		
AN	0.350	0.450		.360	.360	.360	.360		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.156	.155	.156	.157		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64		103.64	103.64	103.64	103.64		
AS	0.260	0.267		.260	.260	.260	.260		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.122	4.125	4.125	4.126		
AV									
Accept/Reject									

Measured by: <i>JP</i>
Date: <i>08/03/15</i> / <i>08/04/17</i>

Audited by: <i>JP</i>
Date: <i>08-04-07</i>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM <i>JP</i>	<i>JP</i>

*DART AEROSPACE LTD		Work Order:	35582
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	210	211	412	By	Date
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.722	.724	.725	.727		
D	0.090	0.110		.102	.102	.103	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.18	2.18	2.18	2.18		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by:	RP
Date:	08/03/18

Audited by:	[Signature]
Date:	08/07/07

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	[Signature]

DART AEROSPACE LTD		Work Order:	3582
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	214	315	416	By	Date
Lathe Section									
A	3.211	3.216							
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.734	.726	.727	.728		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.07	.07	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.180	2.180	2.180	2.180		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by:	AP
Date:	6/2/03/18

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	EA

DART AEROSPACE LTD		Work Order: 35582
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. B / DSK081 Rev. B & record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				17	18	19	20		
Lathe Section									
A	3.211	3.216		3.215	3.215	3.215	3.215		
B	4.946	4.966		4.956	4.956	4.956	4.956		
C	0.718	0.738		.728	.728	.728	.728		
D	0.090	0.110		.102	.102	.102	.102		
E	3.564	3.584		3.574	3.574	3.574	3.574		
F	0.022	0.042		.03	.03	.03	.03		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		.122	.122	.122	.122		
I	2.170	2.190		2.180	2.180	2.180	2.180		
J	4.451	4.471		4.461	4.461	4.461	4.461		
K	0.413	0.433		.423	.423	.423	.423		
L	0.913	0.933		.923	.923	.923	.923		
M									
N									
HAAS Section									
AA	0.240	0.260							
AB	0.490	0.510							
AC	0.140	0.160							
AD	3.510	3.530							
AE	1.633	1.673							
AF	1.493	1.513							
AG	0.040	0.060							
AH	0.188	0.193							
AI	0.140	0.160							
AJ	2.518	2.538							
AK	0.040	0.060							
AL	0.010	0.020							
AM	0.140	0.160							
AN	0.350	0.450							
AO	0.240	0.260							
AP	0.150	0.170							
AQ	0.053	0.073							
AR	101.64	105.64							
AS	0.260	0.267							
AT	0.053	0.073							
AU	4.118	4.138							
AV									
Accept/Reject									

Measured by: RD
Date: 05/03/18

Audited by:
Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	BE

[illegible]

SECTION B-B
SCALE 1:1

TO
CENTER

$$-0.160 \Delta_B$$
 $45.0^{\circ} \pm 0.5^{\circ}$





SECTION A-A
TOOLING HOLE DETAIL
SCALE 1:1





D2940-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRc)
- 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN THIS AREA
WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

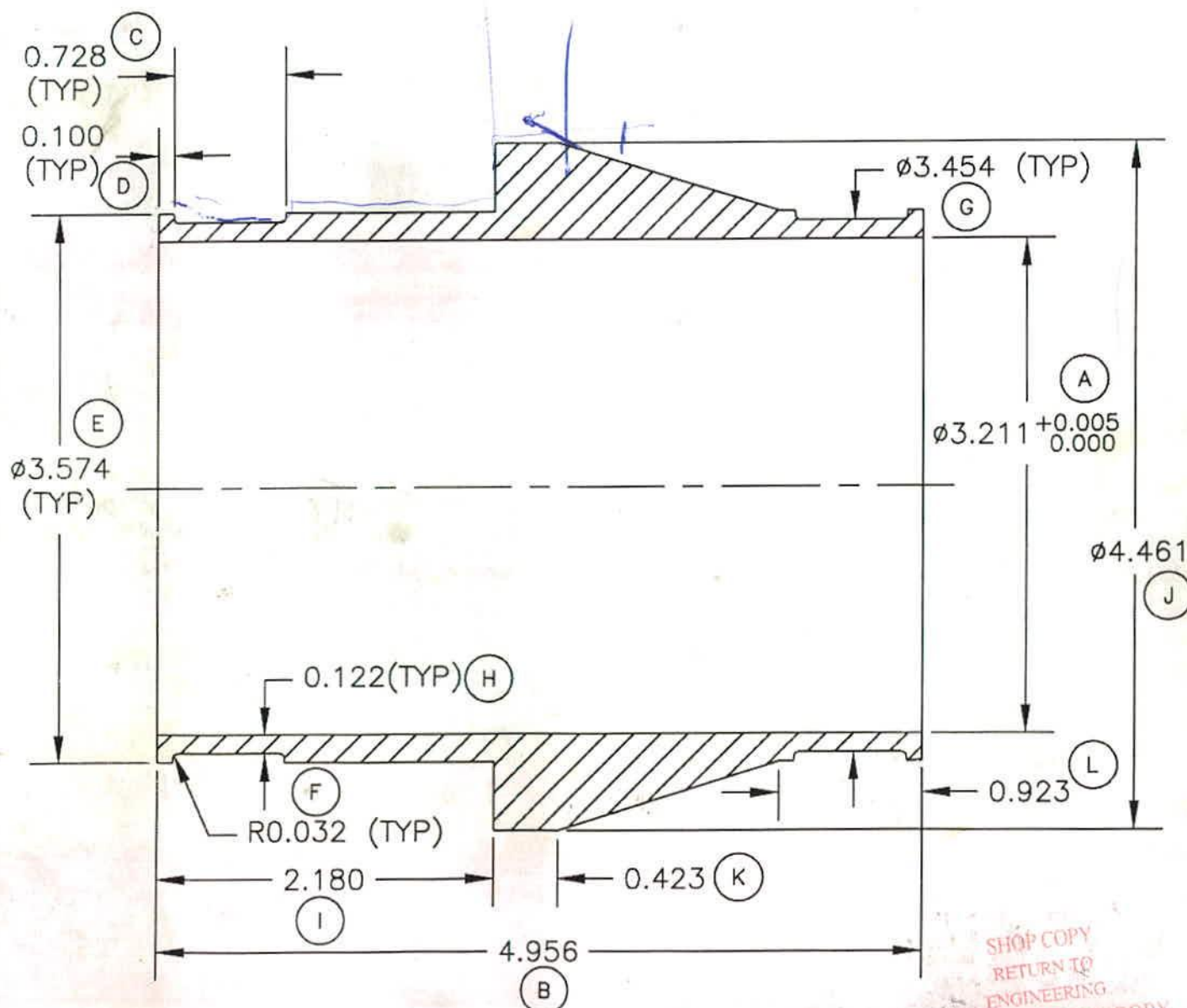
COPYRIGHT © 2001 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	07.03.16	UPDATE PER NCR 642, PRIME INSIDE	
A	01.01.10	NEW ISSUE	
DESIGN		DRAWN BY	
CHECKED		APPROVED	
DATE		TITLE	
07.03.16		ø3.250 SUPPORT	

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSK 081	REV. B SHEET 1 OF 1
DATE 03.06.24		TITLE TURNING DETAIL FOR D2940-1	SCALE 1:1
A	03.03.07	NEW ISSUE	
B	03.06.24	ADDED 4.956 DIMENSION	

RELEASED
03-07-01 #



D2940-1 TURNING DETAIL

SHOP COPY
RETURN TO
ENGINEERING.
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35582

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

$\times 2.974$

